

## ABSTRACT

The object of the present invention is to provide a recycled molded article, not having defects such as sink, warping, bending, and the like, and whose molding contraction does not change substantially depending on its recycle turn number so that said molded article having a good dimensional stability can be manufactured without changing design of the injection molding machine or molding conditions in every turn.

To attain this object, the gas assist injection molding method or the expansion injection molding method wherein gas pressure or expansion pressure is effected on the melted molding material mixture in the mold, are applied in the present invention.

By applying these methods, the melted molding material mixture may fill the mold uniformly and contraction strain by cooling may be absorbed in the inner hollow or the foamed structure in the resulting molded article, and further change of mold contraction depending on recycle turn number is reduced to obtain a molded article having a good dimension stability.